

Date: Wednesday, 4/4/2007 9:14:53 AM
User: Kim Johnston

Process Sheet

| | |
|--|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : GASKET |
| Job Number : 31631 | |
| Estimate Number : 12790 | |
| P.O. Number : <i>N/A</i> | Part Number : D35533 |
| This Issue : 4/4/2007 S.O. No. : <i>N/A</i> | Drawing Number : D3553 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision : A |
| Previous Run : 31402 | Material : <i>N/A</i> |
| Written By : _____ | Due Date : 4/11/2007 Qty: 20 Um: Each |
| Checked & Approved By : <i>[Signature]</i> | |
| Comment : Est Rev:A New Issue 07-03-08 ec | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|------------|----------------------|
| 1.0 | MNEO60S063 | NEOPRENE SHEET 0.063 |
|-----|------------|----------------------|



Comment: Qty.: 0.1523 sf(s)/Unit Total : 3.0450 sf(s)
NEOPRENE SHEET 0.063 *ml 103104 ml 0705 19*

(20)

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
1-Cut as per Dwg D3553
Dwg Rev: *A*
Prog Rev: *A*

ml 0705 19

(20)

2-Deburr if necessary

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 0705 19

(20)

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

[Signature] 23

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

CO 7/15/23 50 (20)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 07/05/23
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:14:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 31631

Part Number: D35533

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

207K5/23

Job Completion



U of 05.23

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

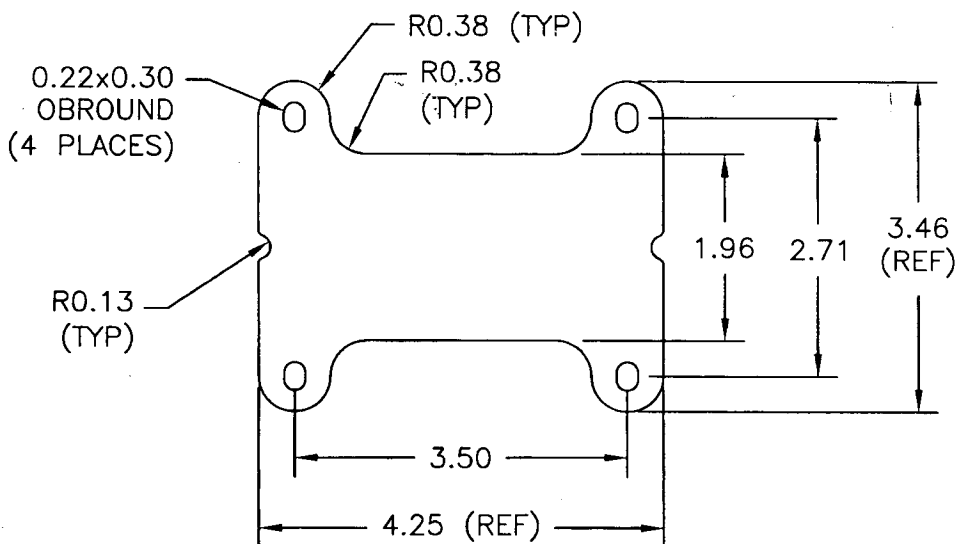
NOTE: Date & initial all entries

DART

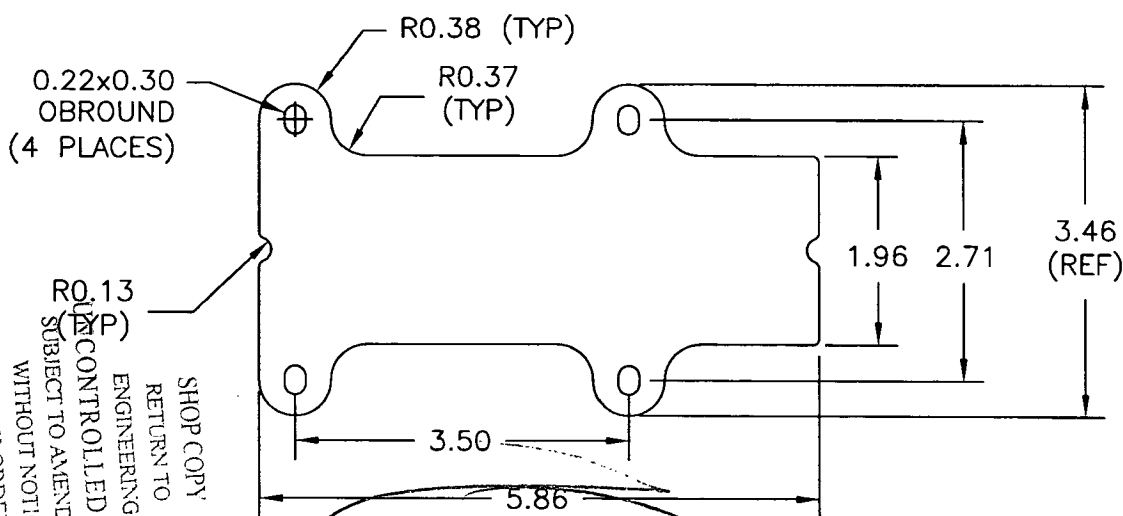
RELEASED

07.02.28

| | | | | |
|---------|--------------------|-------------|--------------------|--------------------------|
| DESIGN | 04 | DRAWN BY | 04 | DART AEROSPACE USA, INC. |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | PORT HADLOCK, WA |
| DATE | 07.01.11 | DRAWING NO. | D3553 | REV. A |
| | | TITLE | GASKET | SHEET 1 OF 1 |
| | | | | SCALE |
| A | | 07.01.11 | NEW ISSUE | 1:2 |



D3553-1 GASKET



D3553-3 GASKET

D3553-1/-3 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF. DART SPEC M-NEO60-S.063)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31631

| | | |
|-------------------------------------|--|----------------------|
| DART AEROSPACE LTD | | Work Order: 31631 |
| Description: Seal GASKET | | Part Number: D3553-3 |
| Inspection Dwg: D3553 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|-----------|---------------------|--------|--------|-------------------------|----------|
| A 0.22x0.30 | +/-0.030 | 0.23x0.310 | ✓ | | VERN | |
| B 3.46 | +/-0.030 | 3.452 | ✓ | | VERN | |
| C 1.96 | +/-0.030 | 1.965 | ✓ | | VERN | |
| D 2.71 | +/-0.030 | 2.714 | ✓ | | VERN | |
| E 5.86 | +/-0.030 | 5.869 | ✓ | | VERN | |
| F 3.50 | +/-0.030 | 3.495 | ✓ | | VERN | |
| G | | | | | | |
| H | | | | | | |
| I | | | | | | |
| J | | | | | | |
| K | | | | | | |
| L | | | | | | |
| M | | | | | | |
| N | | | | | | |
| O | | | | | | |
| P | | | | | | |
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| U | | | | | | |
| V | | | | | | |
| W | | | | | | |
| X | | | | | | |
| Y | | | | | | |

| | | | |
|----------------------|---|---------------------|-----|
| Measured by: ml . ml | Audited by:  | Prototype Approval: | N/A |
| Date: 07.05.19 | Date: 07.05.23 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 04.01.09 | New Issue | KJ/RF | |

